

Date: Friday, 5/25/2007 8:36:41 AM  
User: Kim Johnston

# Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : ARM

EFFECTIVE 07.06.05 AUTH GP  
RELEASED 07.06.06 DATE GP

Job Number : 32645

Estimate Number : 12882

P.O. Number : N/A

This Issue : 5/25/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Previous Run : N/A

Type : SMALL /MED FAB

Part Number : D3560042

Drawing Number : D3560 REV.B

Project Number : N/A

Drawing Revision : B

Material : N/A

Due Date : 6/5/2007

Qty: 30 Um Each

Written By : GP 07.05.25

Checked & Approved By : GP 07.05.25

Comment : Est Rev.A New Issue 07.05.24 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M6061T6B0500X05000

6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 43.9425 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: 17625

2.0 BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 16.750" long

3.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: AA & Dwg D3560 Rev: B

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK





W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.06	11	NO POWDER COAT. CHEM CONV. COAT ONLY. REF ATTACHED DS EMAIL				CP 07.06.06 per QSI/092	07-06-07	
07/06/12	12.5	Press Fit D2808 Bushing 4x B32752	FF	07/06/12		For 06/12	For 06/12	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





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Job Number:



Seq. #: Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)  
PLATE

B 32661

FE.07.06.06

5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weid assembly as per dwg D3560

FE.07.06.08

5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 07.06.07

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/07

(S)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07-06-12

u.m 07.06.07

(S)

4

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

NO POWDER COAT



SEE LWD CHANGE

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

GA





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32645

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description:

140

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

170706/15

Job Completion



170706-15

### POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

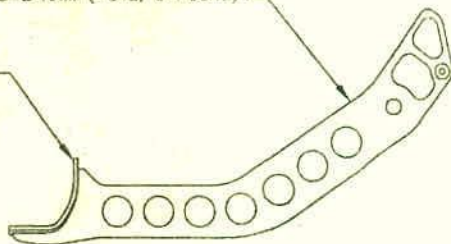
RELEASED u \_\_\_\_\_ DATE 07-06-15





D3560-1 ARM (-041, SHOWN)  
OR D3560-2 ARM (-042, OPPOSITE)

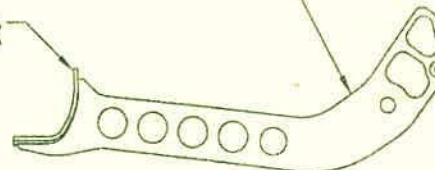
D3592-1 PLATE,  
SEE DETAIL A



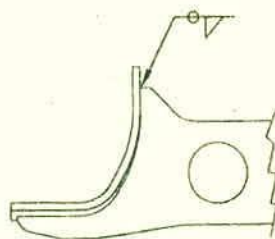
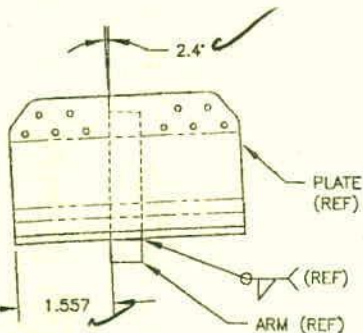
D3560-041 ARM WELDMENT (SHOWN).  
D3560-042 ARM WELDMENT (OPPOSITE).

D3560-3 ARM (-043, SHOWN)  
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,  
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN).  
D3560-044 ARM WELDMENT (OPPOSITE).



**DETAIL A**  
(SCALE 1:1)

**GENERAL NOTES**

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07-05-07

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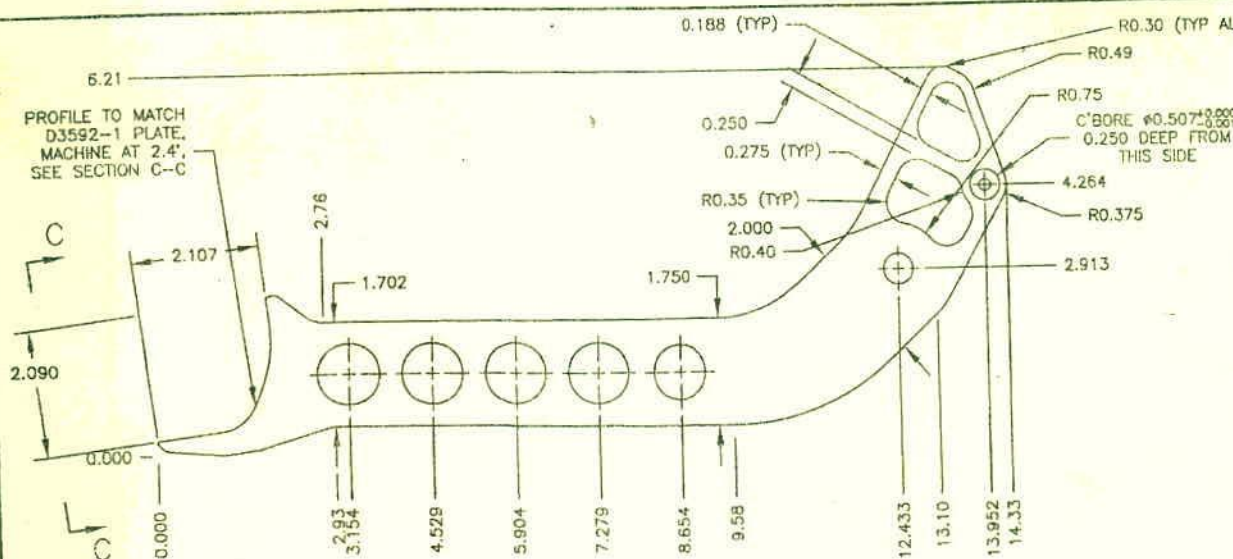
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	APPROVED	DART DART AEROSPACE LTD. MARISSBURG, CHICAGO, ILLINOIS
CHECKED	APPROVED	DRAWING NO. D3560
DATE	07.01.15	TITLE ARM WELDMENT
		SCALE 1:4

WORK ORDER  
326415  
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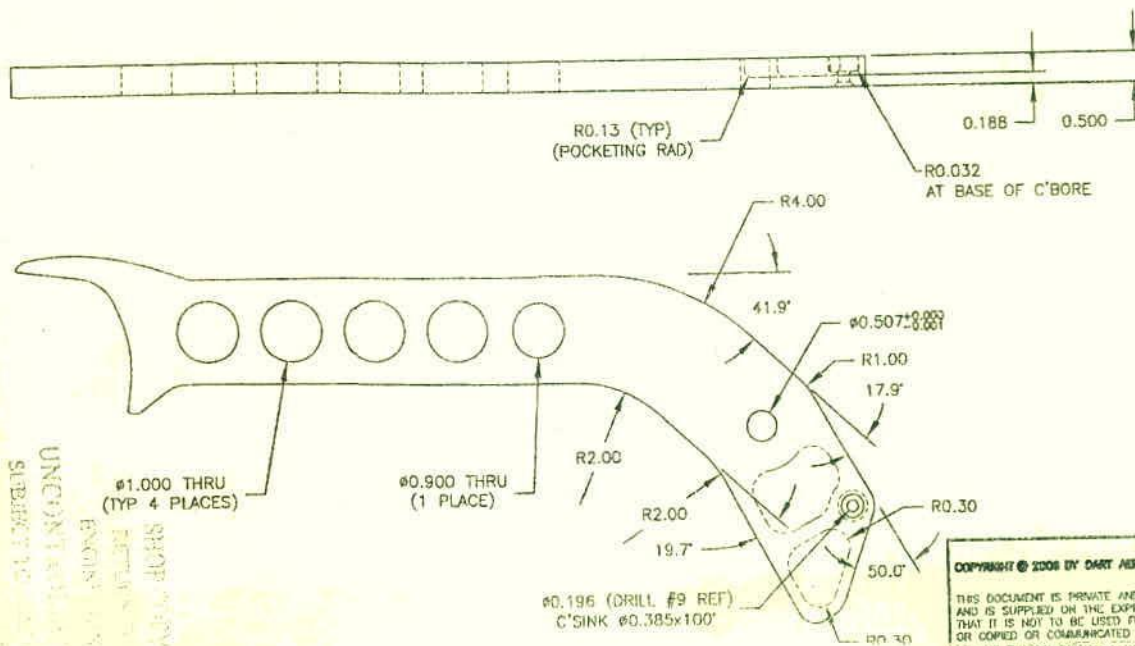


PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4',  
SEE SECTION C-C

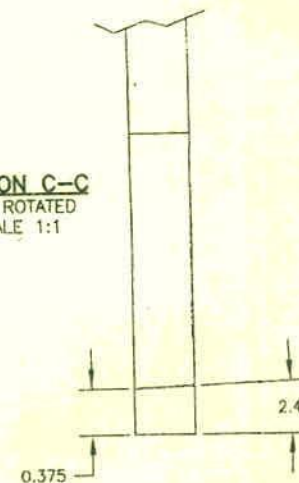


### D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.  
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



### SECTION C-C VIEW ROTATED SCALE 1:1



RELEASED

07.05.07

NO. 32645

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DESIGN	q	DRAWN BY	q	<b>DART</b>	DART AEROSPACE LTD. THUNDERBOLT, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D3560
DATE	07.01.15	TITLE	ARM WELDMENT	REV. B	SHEET 3 OF 3
				SCALE	1:2











DART AEROSPACE LTD		Work Order: 326015
Description: <del>Cross Tube Assembly</del> AT21		Part Number: 3560-2
Inspection Dwg: 23560	Rev: 3	Page: of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	14.73	±.03	14.73	✓			
	φ.507	±.002	.507	✓			
	.250	±.01	.250	✓			
	.188	"	.188	✓			
	.250	"	.250	✓			
	.275	"	.275	✓			
	2.465	"	2.465	✓			
	12.632	"	12.632	✓			
	14.73	±.03	14.73	✓			
	4.481	±.010	4.481	✓			
	5.633	"	5.633	✓			
	.188	"	.188	✓			
	12.632	"	12.632	✓			
	.500	"	.500	✓			
	.507	±.002	.507	✓			
SIDE B	φ.196	±.005	.196	✓			
	3.85 X 1000	±.010	3.85	✓			
	φ1.000	±.010	1.000	✓			
	2.000	"	2.000	✓			
	1.000	"	1.000	✓			
	.375	±.010	.375	✓			
	12.134	±.03	12.13	✓			
	.850	±.01	.850	✓			

Measured by: 3/1

Audited by: JLM

Prototype As: 3/1

Date: 5/1/2001

Date:

Change:

New Issue

Revised by:

KJ/JLM

Approved:





## Chris Provencal

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** June 5, 2007 5:18 PM  
**To:** 'Chris Provencal'  
**Subject:** RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

---

**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Tuesday, June 05, 2007 11:00 AM  
**To:** David Shepherd (David Shepherd)  
**Subject:** D3562-041/-042

David,

For the D3562-041/-042 step weldment, as discussed: They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't do anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

